

Split *End*
Work Order ID 70869-3

Thursday, June 16, 2011 12:43:40 PM

Page 1

Item ID: D3022-1

Revision ID:

Item Name: Seat Pan

Start Date: 6/16/2011 Start Qty: 1.00

Required Date: 6/24/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *W*

QC:

Date:

Date:

Accept

Tooling:

SPC (Y/N):

Set Up/
Run Hours

0.00

0.00

0.00

0.00



Cust Item ID:

Customer:

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D3022

Rev B

100



Waterjet

FLOW CNC Waterjet

204-037

FLOW WATER JET

Memo

1-Cut as per Dwg D3022

Dwg Rev: *B*

Prog Rev: *B*

*** grind direction along 31,700" ***

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

110



QC

Quality Control

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

B 11-6-16

B 11-6-16



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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8 w/ob 1/7

(+3)

Quality Control

130

Bend as per dwg

0.00



Brake NC

NC BRAKE

Memo

0.00

SD w/ob 1/7

(3)

Brake NC

1- Bend as per Dwg D3022

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 w/ob 1/7

(+3)

Quality Control

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

150



Large Fab

Large Fab

Operation
Description

Large Fab

Memo

1-Transfer drill Seat Pan From Frame
Transfer drill in D3022-1 using D3017-041

2-Debur

QC5- Inspect part completeness to step on W/O

Memo

160



QC

Quality Control

Set Up/
Run Hours

0.00

0.00

0.00

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

N/A Now done on 2554
D350.689-041/043

h

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180



Powdercoat

Powder Coating

Grey Sandtex(Ref 4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

h
NA

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

200



Packaging

Packaging

Identify as per dwg & Stock Location:

NA

0.00

Memo

0.00

A 11/11-23 (X1)

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

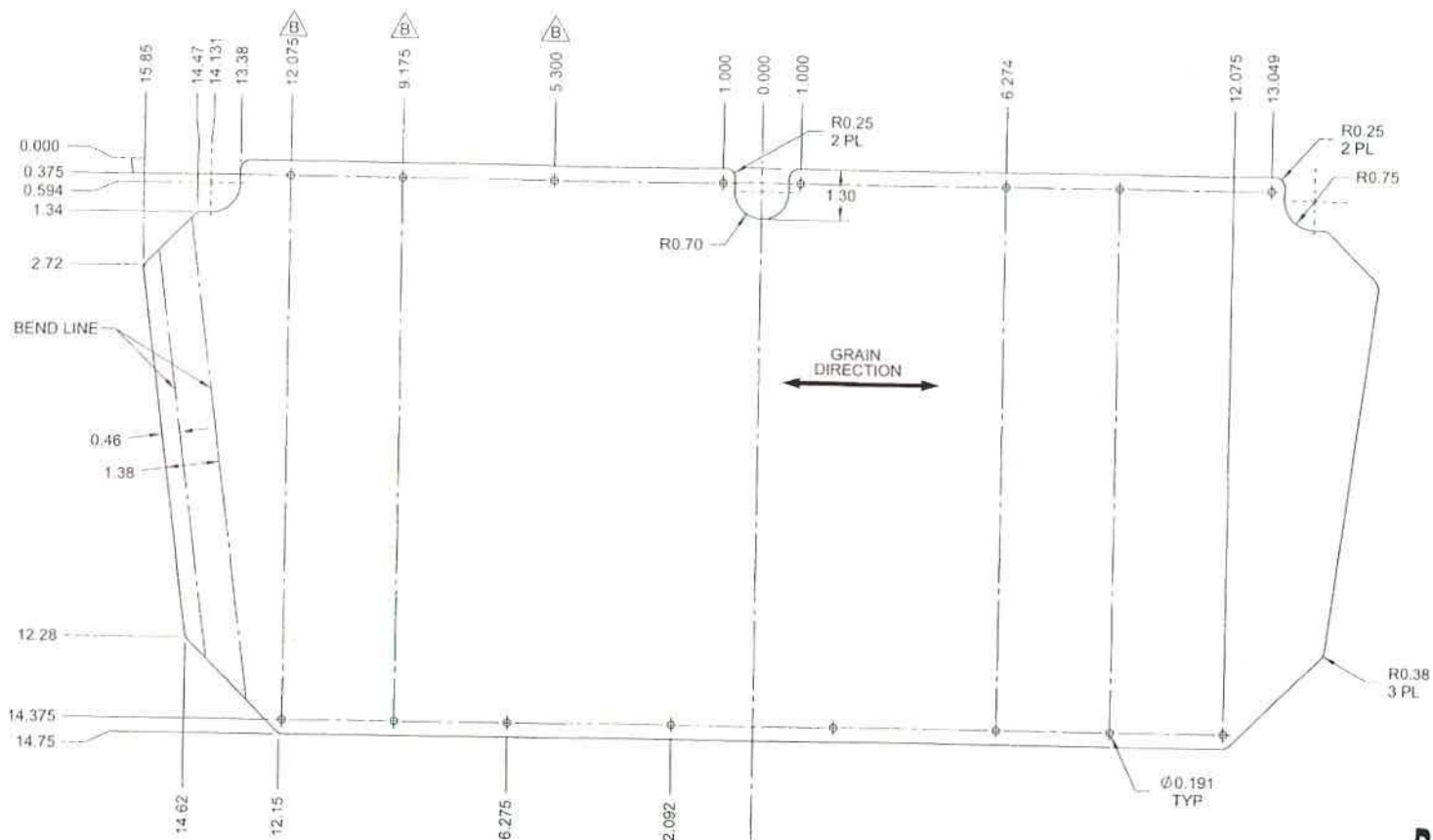
Memo

0.00

Quality Control

6/11/23

6/11/23



RELEASED
08/12/15

NOTES

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN

Handwritten signature

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG APPR.		D3022	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
DATE	08.11.27	COPYRIGHT © 2001 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. ANY DISSEMINATION OF THIS DOCUMENT IS FOR THE PURPOSE OF COMPLETING THE AIR FORCE CONTRACTING PROCESS. ALL RIGHTS ARE RESERVED BY DART AEROSPACE LTD.	

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	M2024T3S.032 / 2024-T3 .032 sheet	Main Warehouse MAT22	68733	DCUSER		49.5000		49.0000		
					4/21/11	-3.0000	113189	-3.0000		-\$10.27
		Main Warehouse MAT22	69131	DCUSER		46.5000		46.0000		
					5/03/11	-3.3000	113189	-3.3000		-\$11.30
		Main Warehouse MAT22	68710	DCUSER		43.2000		42.7000		
					5/03/11	-3.3000	113189	-3.3000		-\$11.30
		Main Warehouse MAT22	70018	DCUSER		39.9000		39.4000		
					5/30/11	-3.0000	113189	-3.0000		-\$10.27
		Main Warehouse MAT22	70017	DCUSER		36.9000		36.4000		
					5/30/11	-3.0000	113189	-3.0000		-\$10.27
		Main Warehouse MAT22	70019	DCUSER		33.9000		33.4000		
					5/30/11	-2.0000	113189	-2.0000		-\$6.85
		Main Warehouse MAT22	70020	DCUSER		31.9000		31.4000		
					5/30/11	-1.5000	113189	-1.5000		-\$5.14
		Main Warehouse MAT22	70869	DCUSER		30.4000		29.9000		
					6/16/11	-6.0000	113189	-6.0000		-\$20.55
		Main Warehouse MAT22	72276	FAUT01		201.9000		23.9000		
					8/08/11	-3.5000	113189	-3.5000		-\$11.99
		Main Warehouse MAT22	71682	DCUSER		198.4000		20.4000		
					8/15/11	-16.6000	113189	-16.6000		-\$56.85
		Main Warehouse MAT22	71629	DCUSER		181.8000		3.8000		
					8/15/11	-16.6000	113189	-3.8000		-\$13.01
								-157.2168		-\$538.44
	M2024T3S.050 / 2024-T3 .050 sheet	Main Warehouse MAT	54982	DCUSER		172.3533		48.0000		
					1/07/10	-2.7000	113189	-2.7000		-\$11.19
		Main Warehouse MAT22	57572	DCUSER		47.0000		4.0000		
					4/13/10	-2.1000	113189	-2.1000		-\$8.71

Location/Lot Activity

November-17-11 11:13:40 AM

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No pick sheet
on original